

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003235**Date Inspected:** 07-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chih-Ming/Huang Wen-Pan			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006 **Component:** OBG side, bottom and deck panels

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC Ultrasonic Testing (UT) technicians UT side to bottom panel joint# SEG-020A-019 and SEG-020-025 SP-080 to BP-022. QC observed what appeared to be weld cap indications from the far side weld cap. ZPMC QC CWI identified as Huang Wen-Pang informed QA that ZPMC personnel would dress the far side weld by grinding and QC would re-examine by UT on 7-8-08 or 7-9-08.

QA observed ZPMC personnel fit floor beam FB13A @ PP-024 on OBG section 4AE.

QA observed ZPMC qualified welding personnel SAW SEG-023A-032 SP-146 to BP-084 following the guide lines of WPS-B-T-2221-B-L2c-S-1. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 29 Amps: 518 Travel speed: 460mm/min

Welder ID: 045265

QA observed ZPMC qualified welding personnel FCAW SEG-019A-025 SP-074 to BP-021 OBG section 4BW

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following the guide lines of WPS-B-T-2231-B-U2-F-1. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 29 Amps: 280 Travel speed: 505mm/min

Welder ID: 20121

QA observed ZPMC personnel fitting component identified as LD11A-W3PP-023 OBG section 3BW.

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns, grinding and weld bevel prep on various OBG components.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

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Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
